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(54) **METHOD AND APPARATUS FOR CALIBRATING A MEASUREMENT SYSTEM**

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\* cited by examiner

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(57) **ABSTRACT**

A method and apparatus for calibrating a measurement system are provided. The method and apparatus compensate not only for lamp variations, but also for camera and optics variations. The system can be readily implemented and can be ported from one measurement system to another. One embodiment of the improved calibration system addresses the issue of variations between light sources by employing an automated lamp calibration system. One method calibrates existing or new lamps to match an established standard. In a preferred embodiment, the method will generate a reference table, for a measurement system defined as the standard, to act as the reference for all measurement systems. The reference table may be in the form of a data file that may be subsequently copied to other measurement systems. The reference table can then act as a global standard for other measurement systems, including future systems not yet made.

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**Related U.S. Application Data**

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(51) **Int. Cl.**<sup>7</sup> ..... **G06F 19/00**

(52) **U.S. Cl.** ..... **702/85; 702/90; 702/189; 356/243.8; 382/165**

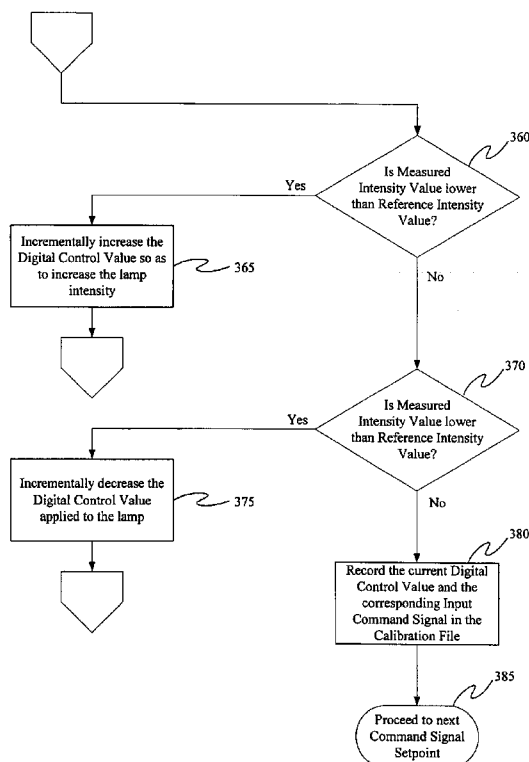
(58) **Field of Search** ..... **702/85, 20, 91, 702/189, 104, 107, 134; 382/162, 165; 356/243.8**

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**U.S. PATENT DOCUMENTS**

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**13 Claims, 6 Drawing Sheets**



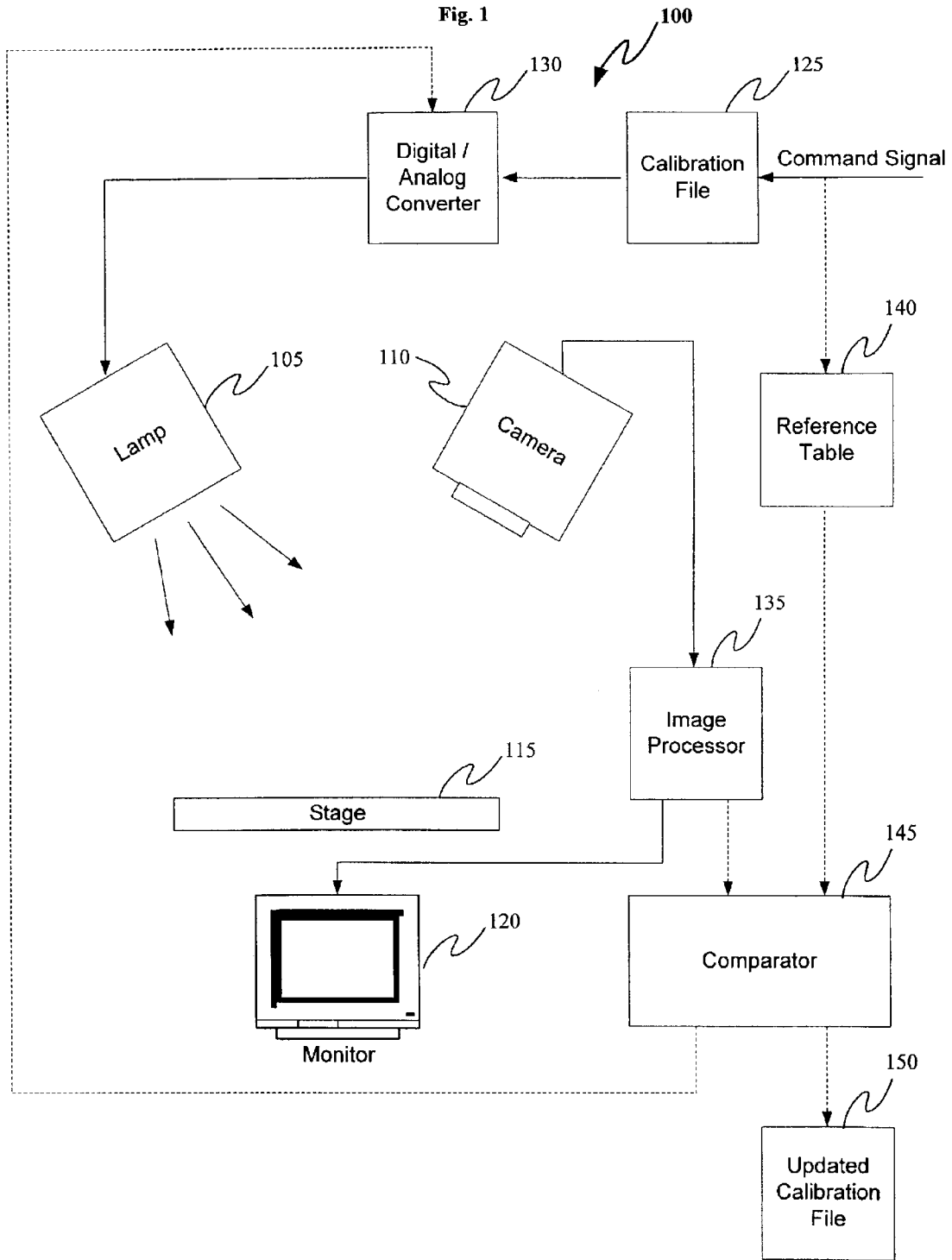
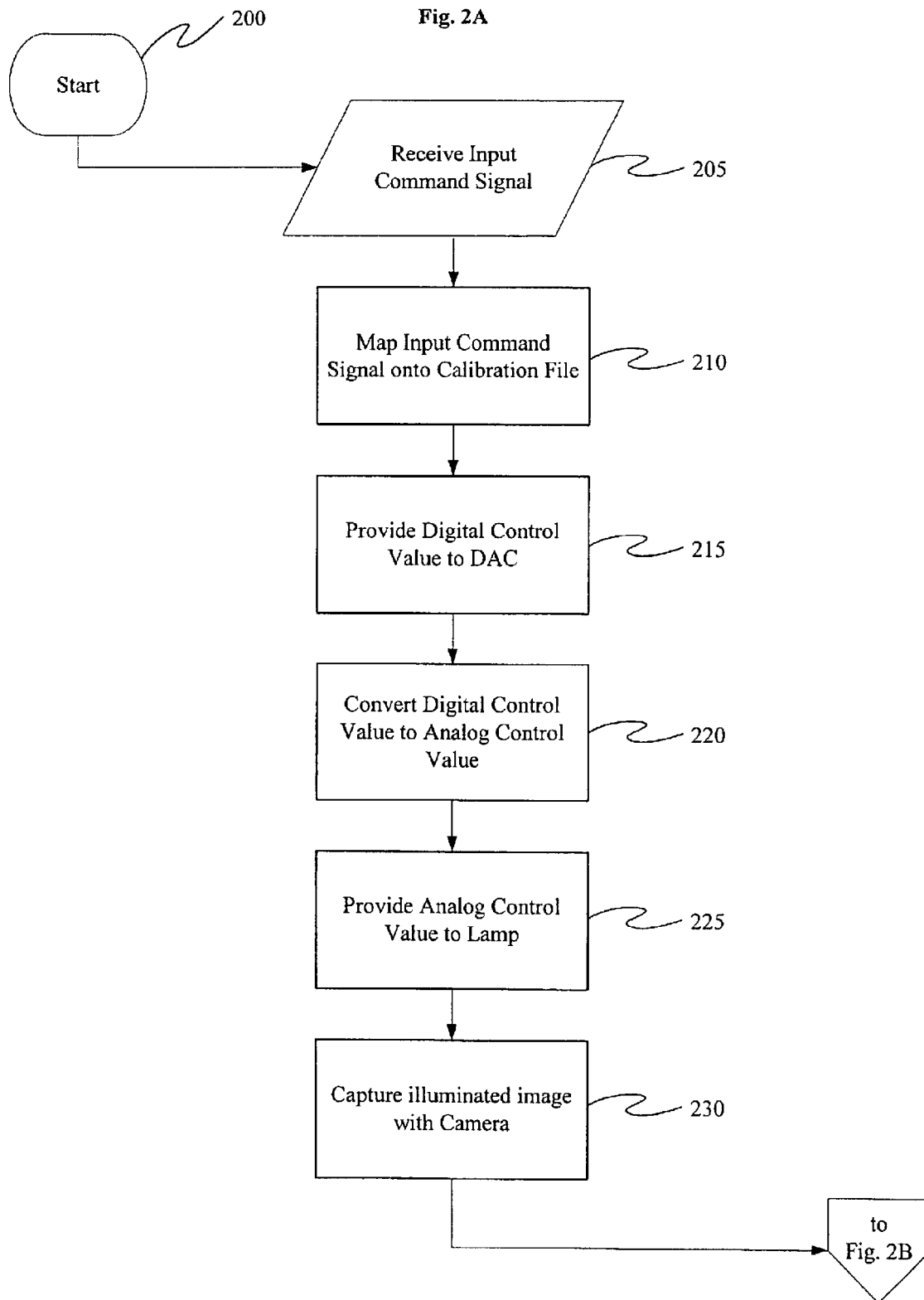
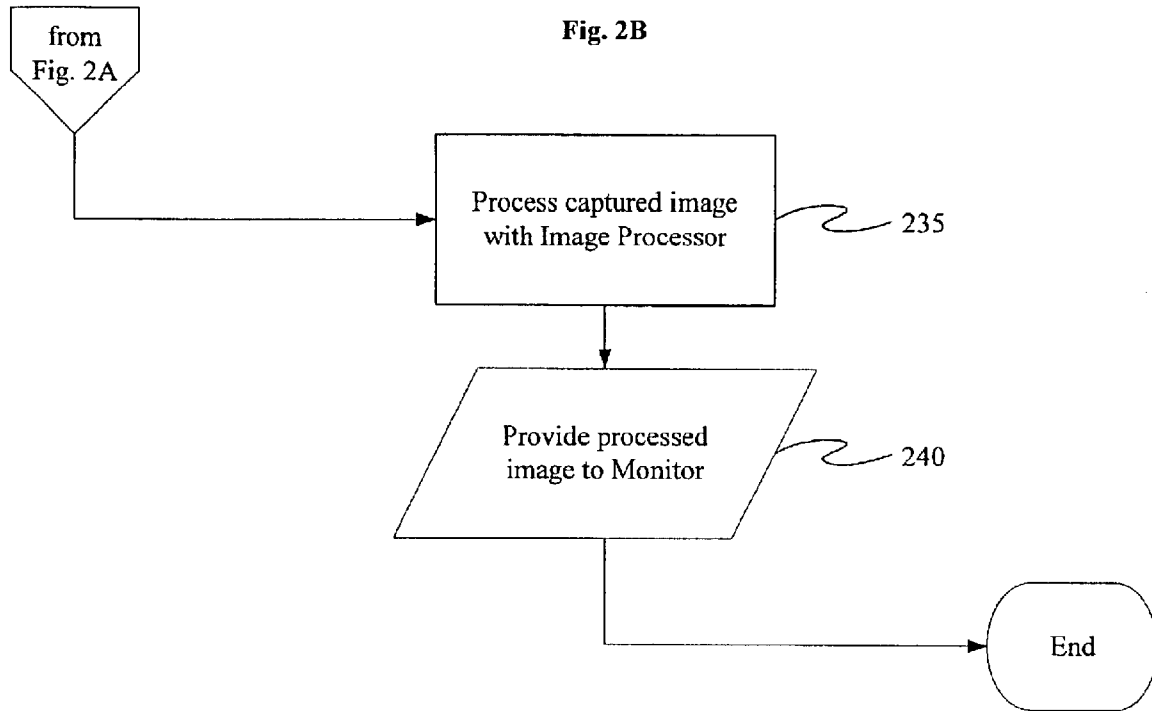
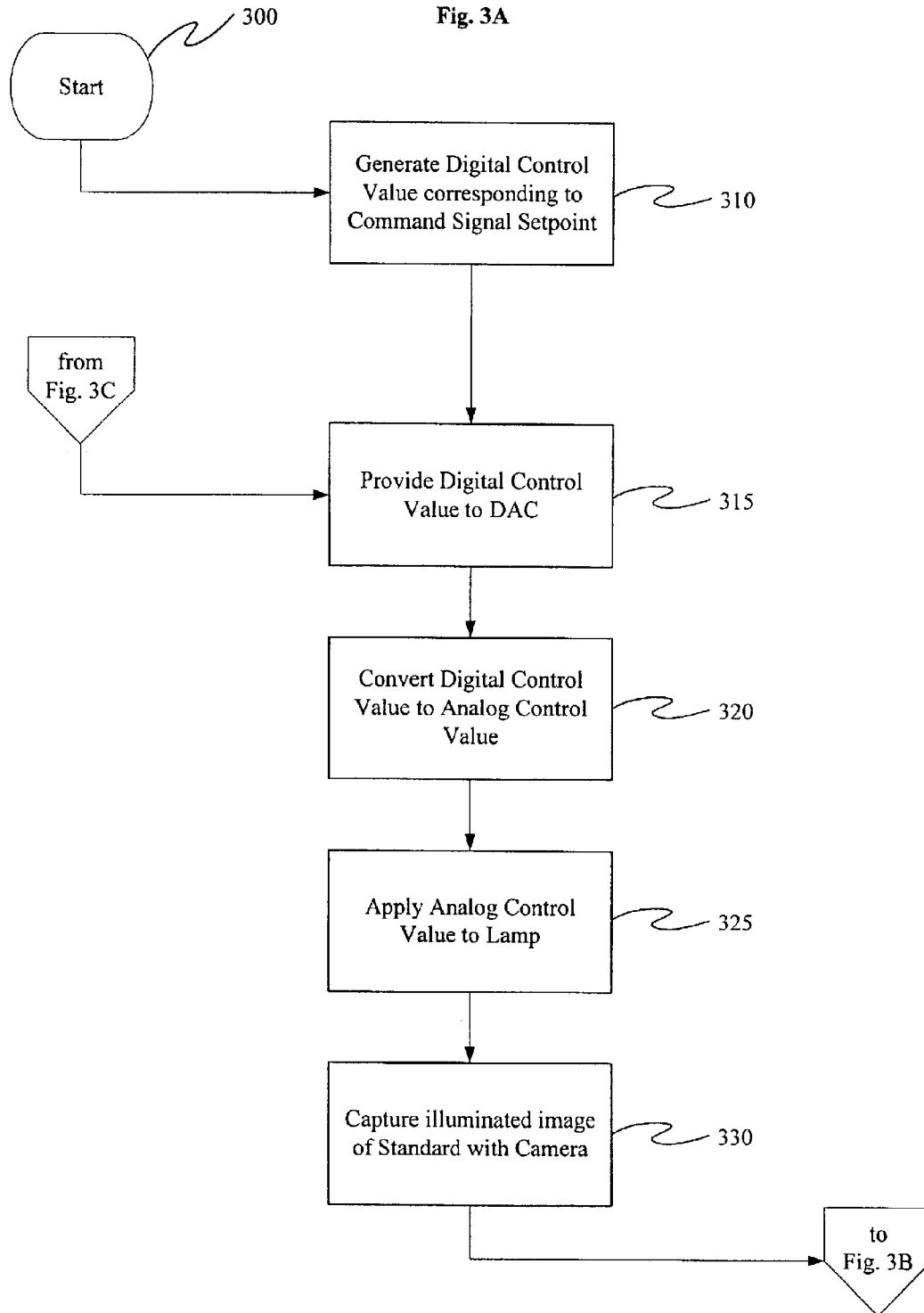
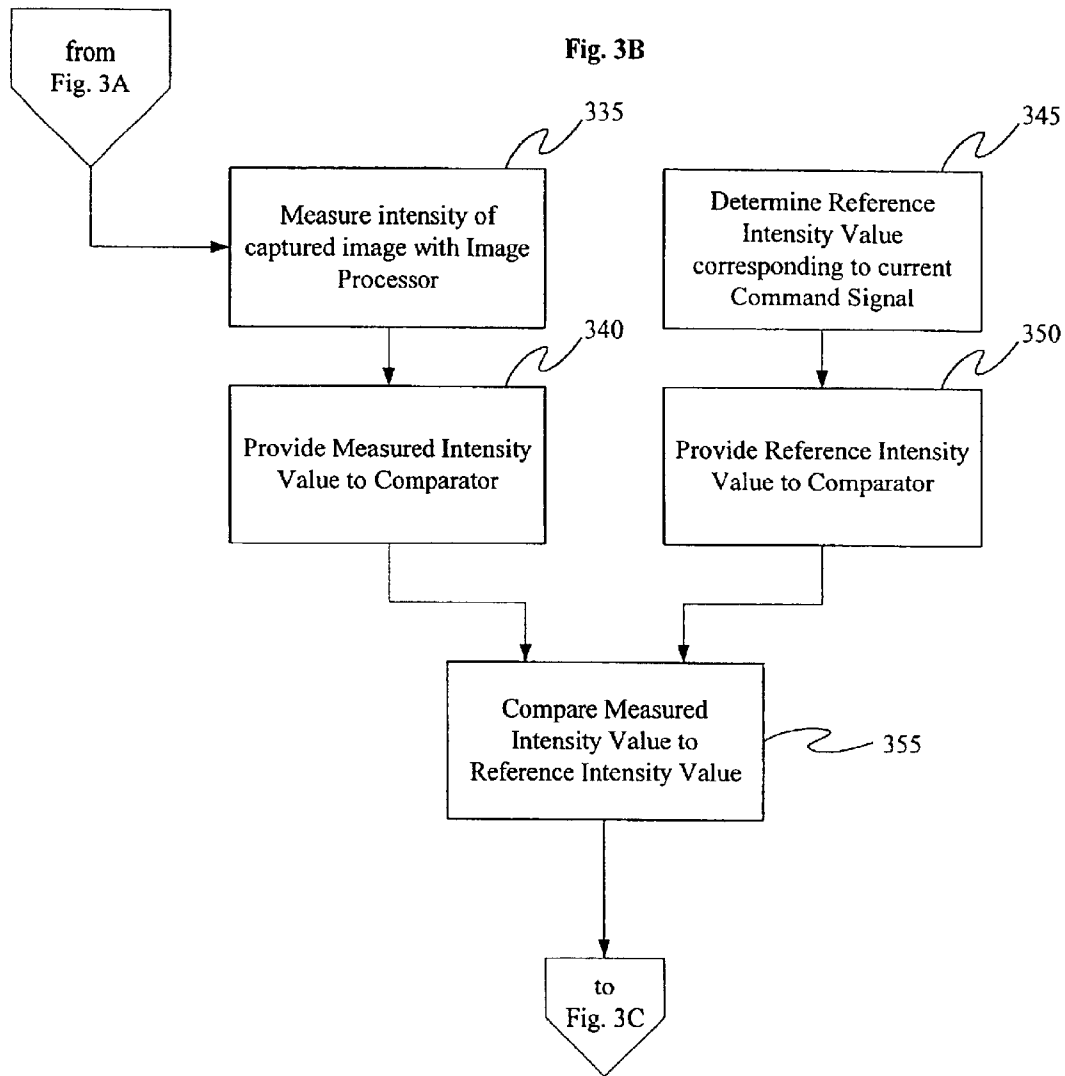


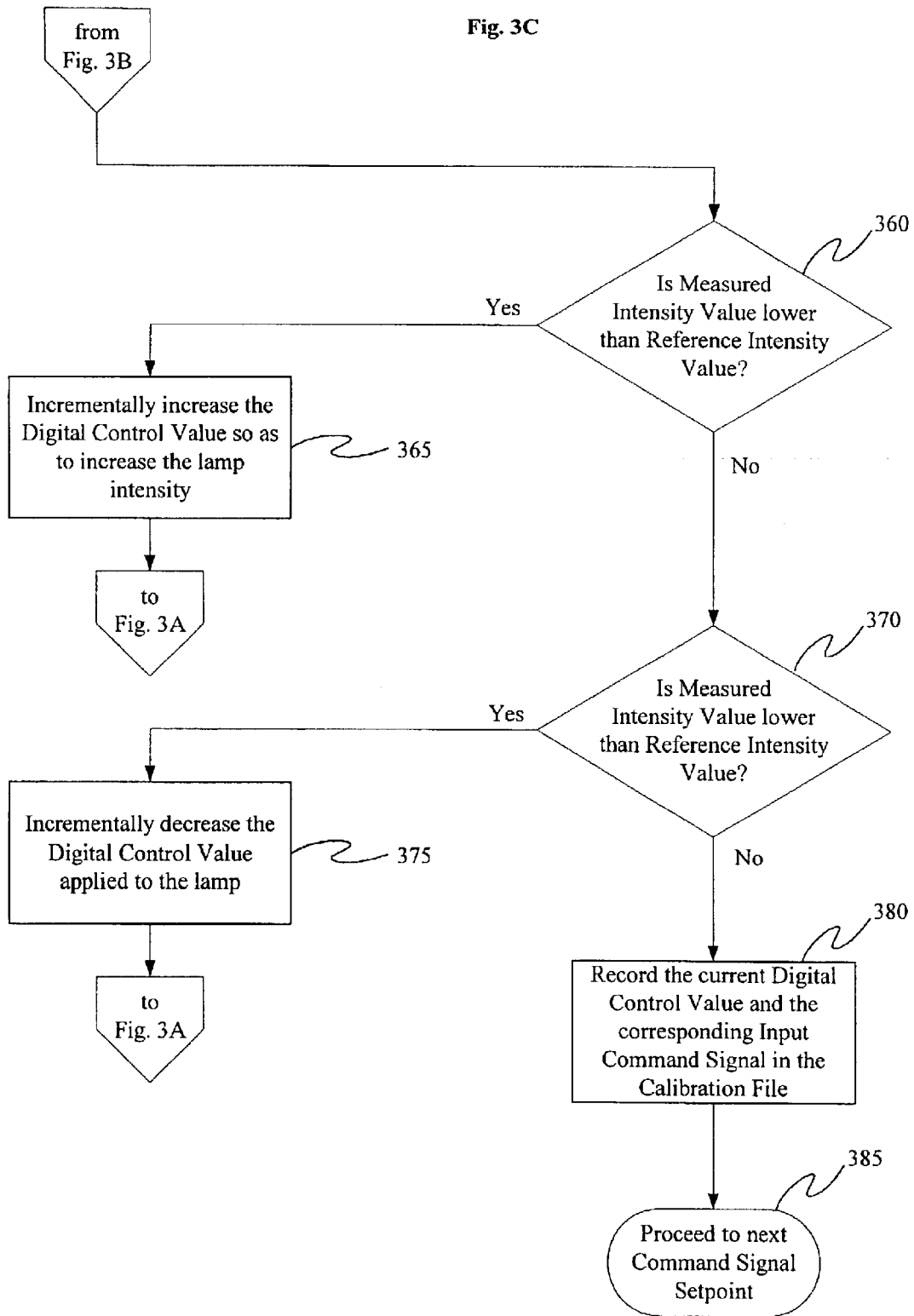
Fig. 2A











**METHOD AND APPARATUS FOR CALIBRATING A MEASUREMENT SYSTEM**

**CROSS REFERENCE TO RELATED APPLICATION(S)**

This application claims the benefit of the filing date of provisional patent application No. 60/335,135 entitled "Method and Apparatus for Calibrating A Measurement System," which has a filing date of Nov. 14, 2001 and which is hereby incorporated by reference.

**REFERENCE TO COMPUTER PROGRAM SUBMITTED ON COMPACT DISC**

A computer program listing appendix submitted on compact disc (in duplicate) is included and the material contained on the compact disc(s) is hereby incorporated by reference.

Filename	Size	Type	Last Modified
Patent Application	74 KB	File Folder	Nov. 14, 2002
LightCalDialog.cpp	45 KB	ASCII text file	Nov. 14, 2002
LightCalDialog.h	4 KB	ASCII text file	Nov. 14, 2002
LightSource.cpp	20 KB	ASCII text file	Nov. 14, 2002
LightSource.h	3 KB	ASCII text file	Nov. 14, 2002

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**BACKGROUND**

Technology has advanced to the stage where a variety of objects are constructed with sub-micron features. For example, computer processors are now designed with sub-micron dimensions. And, a new class of medical devices, known as "micro-medical" devices, also includes sub-micron components.

Quality control and other inspections must be completed on these miniature features. However, measurement systems capable of sub-micron inspection require their own complex technology. These devices generally include a high-powered microscope and extremely precise positioning equipment. Illumination systems, that include one or more lamps, provide the necessary light. However, variations in lamp intensity can cause measurement differences in otherwise identical parts. These illumination variations might occur when replacing lamps, when a lamp ages, or when measuring otherwise identical parts on different systems. What is true for lamps is also true for cameras and optics. One camera may not yield the same results as another on a given measurement system. Therefore, a need exists for a method and apparatus for calibrating a measurement system that will enable consistent measurements.

**BRIEF SUMMARY**

Disclosed herein is a measurement calibration system that compensates not only for lamp variations, but also for

camera and optics variations, to allow consistent measurement to be made across various equipment. The calibration system can be readily implemented on a wide variety of precision measurement systems and can be ported from one measurement system to another. One embodiment of the measurement calibration system addresses the issue of variations between light sources by employing an automated lamp calibration system. One method of the system will calibrate existing or new lamps to match an established standard. In a preferred embodiment, the method will generate a reference table, for a measurement system defined as the standard, to act as the reference for all measurement systems. The reference table may be in the form of a data file that may be subsequently copied to other measurement systems. The reference table can then act as a global standard for other measurement systems, including future systems not yet made. These and other features and advantages of the calibration system will be appreciated from review of the following detailed description of the invention, along with the accompanying figures in which like reference numerals refer to like parts throughout.

**BRIEF DESCRIPTION OF THE DRAWINGS**

FIG. 1 is a block diagram depicting several components of one embodiment of a measurement calibration system.

FIGS. 2A and 2B depict a process flow diagram that describes a process in which a calibration file is utilized to make consistent, precision measurements.

FIGS. 3A, 3B and 3C depict a process flow diagram that describes one embodiment of a process for generating a revised calibration file.

**DETAILED DESCRIPTION**

In the following paragraphs, an improved measurement calibration system will be described in detail by way of example with reference to the attached drawings. Throughout this description, the preferred embodiment and examples shown should be considered as exemplars, rather than as limitations on the present invention. As used herein, "the present invention" refers to any one of the embodiments or equivalents of the invention described herein.

One embodiment of the calibration system addresses, for example, the issue of variations between light sources by employing an automated lamp calibration system. One method of the calibration system will calibrate existing or new lamps **105** to match an established standard. Preferably, the calibration operation will be capable of functioning within the range of approximately 10% to approximately 80% full-scale illumination of the lamp or lamps **105**.

In a preferred embodiment, the method will generate a reference table **140**, for a measurement system **100** defined as the standard, to act as the reference for all measurement systems. The reference table **140** may be in the form of a data file that may be subsequently copied to other measurement systems. The reference table **140** can then act as a global standard for other measurement systems, including future systems not yet made.

Once the reference table is created, the measurement system **100** can perform an adjustment operation on any lamps **150**, old or new, to match their output to the reference table **140**. This is done by creating a calibration file **125** specific to each lamp **105**, and adjusting the lamp control signal to match the standard. In one embodiment, the calibration file **125** will match the output of the lamp **105** to the standard for values between approximately 10% and

approximately 80% full scale. The values below approximately 10% full scale, and above approximately 80%, are reserved to allow headroom to adjust for variations and aging in individual lamps.

For example, after calibration, if an operator selects 44% illumination, the lamp intensity measured by the camera **110** will match the intensity specified in the reference table **140** for that command signal setting within a few A/D counts. If all systems are so calibrated, then for the example setting, the operator's system will match all systems within a few counts. This calibration feature will also calibrate for variations between cameras **110** or anything else in the optical path, ensuring that measurements will not vary from lamp to lamp, or from camera to camera, or from instrument to instrument.

The problem is to ensure that when measuring a given part or object, variations in lamp intensity do not cause measurement differences in otherwise identical parts. These illumination variations might occur when replacing lamps **105**, when a lamp **105** ages, or when measuring otherwise identical parts on different measurement systems **100**. What is true for lamps **105** is also true for cameras **110** and optics. One camera **110** may not yield the same results as another on a given machine. In a preferred embodiment, the calibration process will be semi-automated or automated.

The calibration system **100** can also be retrofitted into existing measurement systems to perform the new calibration process. Generally, the existing lamp control and bulb lamphouse will be replaced with a 12 bit DAC board, and two or more commercial, CE certified lamphouses, such as FOSTEC lamps with remote 0-5 VDC analog control inputs, will be installed. One embodiment will provide an operator command control comprising a 0-100% on/off control with a resolution of 1 part in 100, and transparent to the operator, the lamp control will be mapped to 4,095 (12 bit) DAC values. This permits the lamp **105** to be controlled by the operator or software with precise resolution. This gives backward compatibility to users and preserves the existing interface, but it allows the software to "map" new lamps or re-map aging lamps so they will all behave per the desired measurement standard.

Another embodiment of the calibration system uses one or more neutral density filters and/or gray reflective standards to assist in calibrating the lamps **105**. The filters will attenuate the lamp **105** output at higher intensities that might otherwise saturate the camera **110**. Intense back-light illumination will be viewed through neutral density filters. Intense top light illumination will be viewed from a calibrated gray reflector. In one embodiment, the exact values and natures of these filters and reflectors will be determined experimentally.

One aspect of the improved calibration system is depicted in FIG. 1. FIG. 1 is a block diagram depicting some of the relevant components of a measurement system. Some of these components, such as the lamp **105**, camera **110**, stage **115** and monitor **120**, are implemented as hardware devices. Other components, such as the calibration file **125**, the digital analog converter **130**, the image processor **135**, the reference table **140**, the comparator **145** and the updated calibration file **150**, can be implemented in either hardware or software means.

For background understanding, the operation of the measurement system will first be described with reference to FIG. 1 and FIGS. 2A & 2B. An object to be measured will first be placed on the stage **115**. Based upon the needs of the operator or other measurement necessities, the object will be

illuminated with a lamp **105** to facilitate precise measurements. It is contemplated that the lamp **105** can be implemented in a variety of ways including, for example, a vertical illumination device, a ring illumination device or a back-light illumination device. To further facilitate precise measurements, the intensity of the lamp may be precisely controlled. According to one embodiment, the intensity of the lamp may be varied among 100 different set points. These set points may correspond to a linear scale, an exponential scale, or a variety of other scales depending upon the needs of the measurement system. Accordingly, the measurement system **100** will be provided with an input command signal corresponding to one of these set points (**205**). The command signal is mapped on to a calibration file, which includes a look-up table of input command signals and corresponding digital control values (**210**). For example, an input command signal of 10 may correspond to a digital control value of 369. An exemplary calibration file **125** is included in the following Table 1.

TABLE 1

Command Setpoint	Digital Control Value	Step
0	0	// Step 0
10	369	// Step 1
20	802	// Step 2
30	1227	// Step 3
40	1716	// Step 4
50	2080	// Step 5
60	2588	// Step 6
70	3032	// Step 7
80	3759	// Step 8
90	4095	// Step 9
100	4095	// Step 10

The digital control value corresponding to the command signal is subsequently provided to a digital analog converter **130** (**215**). The digital analog converter **130** converts the digital control value into an actual voltage to be applied to the lamp **105** (**220**, **225**). In this manner, the intensity of the light produced by the lamp **105** will directly correspond to the command signal received by the measurement system **100**. The camera **110** will capture an image of the object resting on the stage **115** at the desired level of illumination (**230**). Depending upon the particular system, the image may be further processed by an image processor **135** so that precise measurements can be calculated (**235**). A monitor **120** may be utilized to facilitate measurements of the object resting on the stage **115** (**240**). Accordingly, it can be seen that the calibration file **125** plays a crucial role in the measurement system by determining the proper intensity of illumination to be provided by the lamp **105**. The process for generating an updated calibration file **150** will be described below.

To generate an updated calibration file **150**, many of the same components described above and depicted in FIG. 1 will be used. In addition, the components connected with the dashed lines in FIG. 1 will be utilized. Typically, a calibration file **125** comprises a plurality of command set points, as shown in Table 1 above. Therefore, the calibration process will be repeated for each desired command set point. To further illustrate this process, reference will be made to FIG. 1, and the process flow diagram depicted in FIGS. 3A-3C. The process starts (**300**) by generating a digital control value corresponding to a desired command signal set point (**310**). The desired command signal set point may be provided from an existing calibration file, or it can be generated on-the-fly by a software process. The digital control value will then be

provided to a digital analog converter **130** to generate a corresponding analog control value (**315**, **320**). The analog control value will be applied to the lamp **105** to generate illumination at a desired intensity (**325**). The illumination provided by the lamp **105** will be applied to a standard that is resting on the stage **115**. The standard resting on the stage **115** can be adapted to the type of lighting that is being applied. For example, a vertical illumination arrangement will require a standard with relatively high reflectivity such as a glass surface. On the other hand, if the lamp **105** is provided as a back-light illumination source, then a reflective standard would not be desired. In fact, one or more neutral density filters may be required to be applied to the camera **110** to prevent saturation of the camera **110**. According to another embodiment, if the lamp **105** is implemented as a ring illumination, a diffuse surface having three-dimensional features may be desired as a standard.

An illuminated image of the standard will be captured by the camera **110** so that a corresponding image signal will be generated (**330**). As previously described, the signal generated by the camera **110** may be processed by an image processor **135** so as to perform processes such as frame grabbing, digitization, or selection of certain areas within the captured image for measurement. The image processor **135** can also measure the intensity of the captured image (**335**). This measured intensity value will be provided to the comparator **145** (**340**). At the same time or previous to these measurements, the system will refer to a reference table **140** to determine a reference intensity value corresponding to the current command signal (**345**). A representative example of a reference table **140** is depicted below in Table 2.

TABLE 2

Command Setpoint	Reference Intensity Value	Filter Instructions
0	0.0000	:
10	53.7425	:insert 0.5 nd filter
20	44.0083	:
30	150.9708	:insert 2.5 nd filter
40	57.3172	:insert 3.0 + 0.5 nd filters
50	92.1128	:
60	163.8533	:
70	47.3972	:insert 3.0 + 1.5 nd filters
80	69.3544	:
90	97.0108	:
100	132.7714	:

The corresponding reference intensity value will also be provided to the comparator **145** (**350**). The comparator **145** will then compare the measured intensity value with the reference intensity value to determine if the current level of illumination provided by the lamp **105** is sufficient (**355**). If the measured intensity value is lower than the reference intensity value (**360**), then the comparator **145** will incrementally increase the digital control value so that the intensity of the lamp **105** will be incrementally increased (**365**). After a brief settling in time, the image intensity measurements will be repeated and another comparison to the reference value will be made (**315–355**). On the other hand, if the measured intensity value is lower than the reference intensity value (**370**), then the digital control value will be incrementally decreased so as to decrease the intensity of the lamp **105** (**375**). Similarly, after a brief settling in time, the process of measuring the intensity of image and comparing it with a reference intensity value will be repeated (**315–355**). Appropriate “centering” algorithms may be utilized to settle the lamp intensity at or near the desired reference intensity value.

If, however, the measured intensity value is within acceptable tolerances of the reference intensity value, then the current digital control value being applied to the digital analog converter **130** will be recorded along with its corresponding input command signal in an updated calibration file **150** (**380**). After this, the process repeats at the next command signal set point (**385**).

Although certain embodiments and aspects of the present inventions have been illustrated in the accompanying drawings and described in the foregoing detailed description, it will be understood that the inventions are not limited to the embodiments disclosed, but are capable of numerous rearrangements, modifications and substitutions without departing from the spirit of the invention as set forth and defined by the following claims and equivalents thereof. Applicant intends that the claims shall not invoke the application of 35 U.S.C §112, ¶6 unless the claim is explicitly written in means-plus-step or means-plus-function format.

I claim:

**1.** A method of generating a calibration file for use with a measurement system, the method comprising performing a) through k) for each of a plurality of command signal setpoints:

- a) generating a digital control value corresponding to the command signal setpoint;
- b) converting the digital control value to a corresponding analog control value;
- c) applying the analog control value to a light source whereby the intensity of the light source depends upon the analog control value;
- d) measuring the intensity of the light source with an image capturing device;
- e) providing a measured intensity value to a comparator;
- f) determining a reference intensity value corresponding to the command signal setpoint;
- g) providing the reference intensity value to the comparator;
- h) comparing the reference intensity value to the measured intensity value;
- i) if the measured intensity value is lower than the reference intensity value, then incrementally increasing the digital control value applied to the light source and repeating b).through h);
- j) if the measured intensity value is higher than the reference intensity value, then incrementally decreasing the digital control value applied to the light source and repeating b) through h); and
- k) if the measured intensity value is within the acceptable tolerances, then recording the current digital control value and the corresponding command signal setpoint in a calibration file.

**2.** A method according to claim **1**, wherein incrementally increasing the digital control value and repeating b) through h) further comprises increasing the digital control value by a fixed increment until the measured intensity value is greater than the reference intensity value and then reducing the amount of the fixed increment; and

wherein incrementally decreasing the digital control value and repeating b) through h) further comprises decreasing the digital control value by a fixed increment until the measured intensity value is lower than the reference intensity value and then reducing the amount of the fixed increment.

3. A method according to claim 1 wherein measuring the intensity of the light source further comprises:

- generating an electronic image of a standard with a digital camera;
- frame grabbing the electronic image;
- digitizing the electronic image;
- selecting a portion of the digitized electronic image; and
- measuring the intensity of the selected portion of the digitized electronic image.

4. A method according to claim 1 further comprising: providing a standard for measuring intensity of light; and wherein measuring the intensity of the light source further comprises measuring an amount of light reflected from the surface of the standard.

5. A method according to claim 4 wherein the standard comprises a reflective glass surface.

6. A method according to claim 4 wherein the standard comprises an opaque object.

7. A method according to claim 4 wherein the standard comprises a diffuse surface.

8. A method according to claim 1 further comprising providing a neutral density filter between the light source and the image capturing device so as to prevent saturation of the image capturing device.

9. A method according to claim 8 wherein providing a neutral density filter is performed in response to an instruction within a reference table.

10. A computer program product operable to calibrate the operation of a precision measurement instrument, the computer program product comprising a computer memory encoded with instructions for performing the a) through k) for each of a plurality of command signal setpoints:

- a) generating a digital control value corresponding to the command signal setpoint;
- b) converting the digital control value to a corresponding analog control value;
- c) applying the analog control value to a light source whereby the intensity of the light source depends upon the analog control value;
- d) measuring the intensity of the light source with an image capturing device;
- e) providing a measured intensity value to a comparator;
- f) determining a reference intensity value corresponding to the command signal setpoint;

g) providing the reference intensity value to the comparator;

h) comparing the reference intensity value to the measured intensity value;

i) if the measured intensity value is lower than the reference intensity value, then incrementally increasing the digital control value applied to the light source and repeating b) through h);

j) if the measured intensity value is higher than the reference intensity value, then incrementally decreasing the digital control value applied to the light source and repeating b) through h); and

k) if the measured intensity value is within the acceptable tolerances, then recording the current digital control value and the corresponding command signal setpoint in a calibration file.

11. A computer program product according to claim 10, wherein the instructions for incrementally increasing the digital control value and repeating b) through h) further comprise increasing the digital control value by a fixed increment until the measured intensity value is greater than the reference intensity value and then reducing the amount of the fixed increment; and

wherein the instructions for incrementally decreasing the digital control value and repeating b) through h) further comprise decreasing the digital control value by a fixed increment until the measured intensity value is lower than the reference intensity value and then reducing the amount of the fixed increment.

12. A computer program product according to claim 10 wherein the instructions for measuring the intensity of the light source further comprise:

- frame grabbing an electronic image generated by the image capturing device;
- digitizing the electronic image;
- selecting a portion of the digitized electronic image; and
- measuring the intensity of the selected portion of the digitized electronic image.

13. A computer program product according to claim 10 further comprising instructions for prompting an operator to provide a neutral density filter between the light source and the image capturing device in response to an instruction within a reference table.

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